

Work Order ID 157083

Monday, February 13, 2017 11:23:18 AM

157083

Page 1

Item ID: D3172-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Base Assembly
Start Date: 3/6/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 3/16/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:
Approvals: Process Plan:  Date: FEB 13 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3172	D

100

0.00

100

Large Fab

Large Fab

Large Fab

Memo

3.33

1-Cut Qty 4 D3166-1 as per Dwg D3172

2-Cut 3/4" x 3/4" square tubing as per Dwg D3172

3-Drill holes in D3172-3 as per Dwg D3172

4-Deburr & Remove all markings from material

5-Weld all ribs as per Dwg D3172 using Welding Table

6- Use DT 8996 jig to locate D3174-1 as per dwg

7- Weld D5365-1 as per dwg in (2) locations. From edge of back basket corn (without hinge) to bottom of D5365-1 lug. And (2) located at the front.

8- Weld mesh as per dwg

1 MAR 20 2017

DAS
24
9-89

1x DG 2017/03/14

1 CC 17-3-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>157083</u> Part No. <u>D3172-041</u> NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: <u>12/2/14</u>		Step #: <u>100</u>		QTY Effective: _____			MRB (QSI042) Approval DAS 12 9-89 <u>12/2/14</u>		
Description Work Order Deviation				Disposition				Completed By	
Holes in D3174-1 do not have correct spacing due to shrinkage. 				Acceptable to fill lower lower by with weld and drill to correct spacing. No action needed. PD. 17-03-22.				Lead hand / Supervisor Approval Verification	
QC / QA Coordinator Approval				QC / QA Coordinator Approval				QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				<u>①</u>	<u>17-03-23</u>		DAS 9 9-89
120 *120* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				<u>①</u>	<u>17-03-23</u>		DAS 9 9-89
125 *125* HandFinish Hand Finishing	Pressure Wash per QSI005 4.3 Memo	0.00 0.01				<u>(X1) ①</u>			20170322 BEB

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
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Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M136657</i> Memo 1ST COAT: <i>2:35</i> START TIME: <i>2:35</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>3:05</i> ***** 2nd coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.01				<i>1</i>	<i>0</i>	<i>17-03-22</i>	<i>34</i> <i>9-88</i>
140 *140* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.03							<i>1 of 14105/27</i>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
9-13-14 Jc JMS			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐	

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Item ID: D3172-041 Accept ***N900040100*** Setup Start ***NS1***
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Required Date: 3/16/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location <u>u/b</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.02							
Quality Control									

**DAS
21
9-80**

MAR 27 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
Equip/Tooling ☐		Supplier ☐		Cracks ☐		Broken/Damage/Defect ☐	
Handling/Pre ☐		Training ☐		Crimp/Kink/Ripple/Wave ☐		Inspection Incomplete/Unqualified ☐	
Material ☐		Use for Testing ☐		Cuffs ☐		Contamination ☐	
Internal Transport ☐		Poor Information ☐		Crushing ☐		Countersink ☐	
Tribal Knowledge ☐		Rushing ☐		Heat Treat ☐		Cut Too Short ☐	
LOA ☐		Product Improvement ☐		Wave/Twist in Tube ☐		Instructions Incomplete/Unclear ☐	
Substation ☐		Process Improvement ☐		Marks/Chatter ☐		Drill Holes ☐	
Past Expiry Date ☐		Manufacturing Process ☐		OTHER : _____			
Misidentified ☐		Past Due ☐					

Picklist Print

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Page 1

Work Order ID: 157083

157083

Parent Item: D3172-041

D3172-041

Parent Item Name: Basket Base Assembly

Start Date: 3/6/2017

Required Date: 3/16/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:B04.01.05Added Step 5 inspectionKJ/RF
IPP Rev:C 08-08-29 revC as per dwg DD verified by:EC IPP Rev:D
11.04.04 added pressure wash DD VERF:EC IPP REV:E 16.11.03 AS
PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

✓ D2232-3 *D2232-3* Basket Hinge		Manufactured	No			100	Each	14.0000	2	2			
									**	DG 2017/03/14			

Location

WA004

141081

143693

148935

Loc Qty

14

1

1

12

Loc Code

B148935 → 2

✓ D2327-3 *D2327-3* Spacer Bushing		Manufactured	No			100	Each	63.0000	2	2			
									**	DG 2017/03/14			

Location

WA004

148585

154190

Loc Qty

63

13

50

Loc Code

B148585 → 2

✓ D2581 *D2581* Mounting Bracket		Manufactured	No			100	Each	82.0000	2	2			
									**	DG 2017/03/14			

Location

WA004

132771

136270

139082

147603

148944

152803

155305

Loc Qty

82

1

2

2

2

3

48

24

Loc Code

B156869 → 2

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
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Misidentified ☐	Past Due ☐																																																																

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Parent Item: D3172-041

D3172-041

Parent Item Name: Basket Base Assembly

Start Date: 3/6/2017

Required Date: 3/16/2017

Start Qty: 1.00

Required Qty: 1.00

✓ D3166-1
D3166-1
Basket Hoop

Manufactured No

100 Each 11.0000 4 4

**

DC 2017/03/14

Location

Loc Qty

Loc Code

WA004

11

B157365 →

4

146421

5

153889

6

100 Each 10.0000 8 8

**

DC 2017/03/14

✓ D3174-1
D3174-1
Mounting Lug

Manufactured No

Location

Loc Qty

Loc Code

WA004

10

B157401 →

8

152668

2

153538

8

100 Each 0.0000 4 4

**

DC 2017/03/14

✓ D5365-1
D5365-1
Lug

Manufactured No

B157406 →

**

DC 2017/03/14

✓ M304EX0.75-16F

Purchased No

100 sf 1,038.300 48 48

**

MAR 16 2017

DAS
24
9-89

✓ ***M304FX0 75-16F***
Expanded Metal Flat SS

Location

Loc Qty

Loc Code

WA004

1038.29996

M136012

168.29996

M136467

230

M136612

640

B M136991 → 33

M136951 → 15

DQA: _____ Date: _____



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D3172-041

Parent Item Name: Basket Base Assembly

Start Date: 3/6/2017

Required Date: 3/16/2017

Start Qty: 1.00

Required Qty: 1.00

M304TS0.750W.065

Purchased

No

100

f

862.6249

51

53.68421

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

SG 2017/03/14

Location

Loc Qty

Loc Code

WA004

862.624944

B136907 →

54

m133412

2.264944

m135655

400

m136378

460.36

DQA: _____ Date: _____

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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
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							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER :							

PARTS LIST FOR D3172-041 BASKET BASE ASSEMBLY

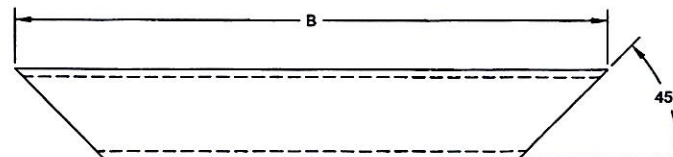
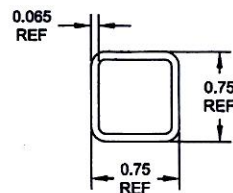
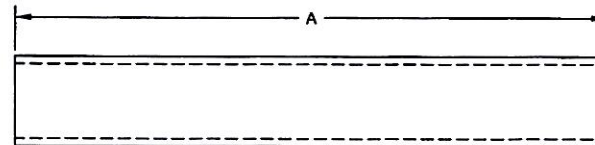
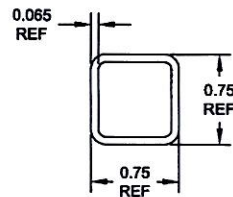
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D3172-1	2	—	96.00	RIB
D3172-3	2	—	25.50	RIB
D3172-5	6	33.00	—	RIB
D3172-7	3	26.81	—	RIB
D3172-9	1	94.50	N/A	RIB
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D3166-1	4	N/A	N/A	RIB
D3174-1	8	N/A	N/A	MOUNTING LUG
D5365-1	4	N/A	N/A	LUG

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 NO. 157083

FEB 13 2017

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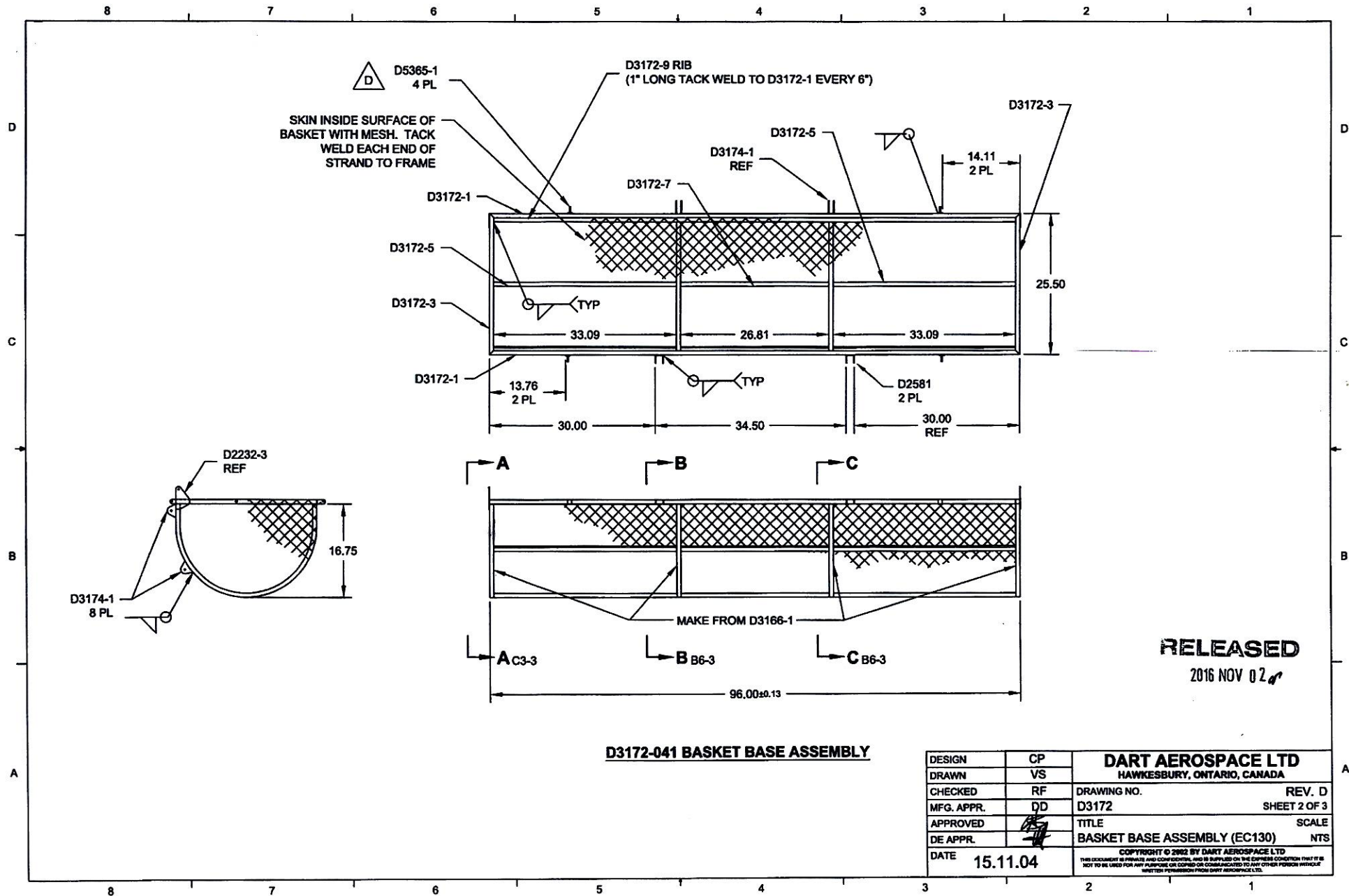
2016 NOV 02
 ECN 16-515 9



- NOTES:**
- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
 - 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
 - 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 7) IDENTIFICATION: NONE
 - 8) WEIGHT: N/A
 - 9) WELD PER DART QSI 004

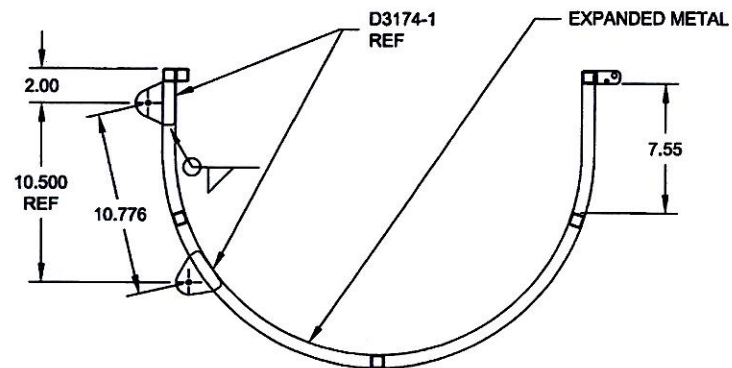
REV.	DESCRIPTION	BY	DATE
D	REPLACED D2012-117 WITH D5365-1 (ZN C6-1, D5-1, C5-2, D3-2, C3-2)	VS	15.11.04
C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.03
B	ADD D3172-9 & D2012-117	CP	03.01.07
A	NEW ISSUE	DS	02.12.02
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF		
MFG. APPR.	RD		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	DRAWING NO. D3172 TITLE BASKET BASE ASSEMBLY (EC130) SCALE NTS	
DATE	15.11.04	REV. D SHEET 1 OF 3	

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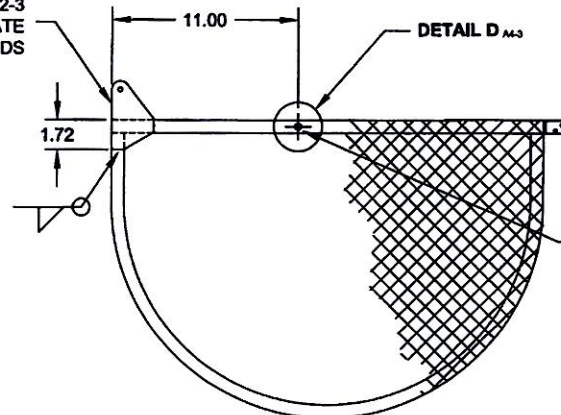
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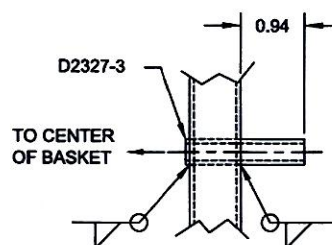


**SECTION B-B^{B5-2}
AND SECTION C-C^{B3-2}**
RIB DETAIL
SCALE 2X

D2232-3
HINGE PLATE
BOTH ENDS



SECTION A-A^{B5-2}
SPACER DETAIL
SCALE 2X



DETAIL D^{D3-3}
SCALE 4X

RELEASED

2016 NOV 02 47

B

A

D

C

B

A

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	RF	DRAWING NO.	REV. D
MFG. APPR.	DD	D3172	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (EC130)	NTS
DATE	15.11.04	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1